

Work Order ID 78971

78971

Page 1

January-17-12 2:57:21 PM

Item ID: D4149-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Crosstube Lug Assembly, Aft
 Start Date: 17/01/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 31/01/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/01/17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4149	C								
100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per dwg								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>51468</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

JP 12/01/17 2

8, 2/1/23

JP 12-01-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

12/1/24
(2)

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 78971

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Parent Item: D4149-041

D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM
11.03.03 as per revC DD verf:JLM

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS21043-3

Purchased

No

100

Each

1,243.000

4

4

MS21043-3

Nut

**

EP, 2/01/23

Location

Loc Qty

Loc Code

FG

72

103691

72

ST300

632

119901

632

ST301

539

118077

2

118614

441

118686

30

119758

66

4

MS21043-4

Purchased

No

100

Each

1,035.000

1

6

MS21043-4

Nut

**

EP, 2/01/23

Location

Loc Qty

Loc Code

FG

40

104603

40

ST300

470

118686

470

ST301

525

119309

29

119546

496

46

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Parent Item: D4149-041

D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 2.00

Required Qty: 2.00

D3910-1 Manufactured No 100 Each 26.0000 1 2
D3910-1
 Crosstube Lug

**

EP 12/01/23

Location	Loc Qty	Loc Code
st507	26	
78326	26	

2

D4091-1 Manufactured No 100 Each 11.0000 1 2
D4091-1
 Mounting Lug

**

EP 12/01/23

Location	Loc Qty	Loc Code
ST458	11	
77320	11	

2

D4149-1 Manufactured No 100 Each 21.0000 2 4
D4149-1
 Crosstube Lug Plate, Aft

**

EP 12/01/23

Location	Loc Qty	Loc Code
ST133	21	
78044	21	

4

D4149-3 Manufactured No 100 Each 36.0000 1 2
D4149-3
 Spacer

**

EP 12/01/23

Location	Loc Qty	Loc Code
ST133	36	
78046	36	

2

D4149-5 Manufactured No 100 Each 4.0000 1 2
D4149-5
 Eyebolt Stud

**

EP 12/01/23

Location	Loc Qty	Loc Code
ST133	4	
73548	4	

2

January-17-12 2:57:25 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D4149-041

D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 2.00

Required Qty: 2.00

AN3C12A Purchased No

100 Each 40.0000 2 4

AN3C12A

Bolts

**

EP 12/01/23

Location

Loc Qty

Loc Code

ST351

40

117514

4

118112

5

118422

8

118451

22

119510

1

AN4C13A Purchased No

100 Each 39.0000 3 6

AN4C13A

BOLT

**

EP 12/01/23

Location

Loc Qty

Loc Code

ST357

39

120187

39

MS20615-4M18 Purchased No

100 Each 407.0000 3 6

MS20615-4M18

Rivet

**

EP 12/01/23

Location

Loc Qty

Loc Code

ST323

407

118077

243

118543

164

NAS1149C0332R Purchased No

100 Each 2,846.000 4 8

NAS1149C0332R

Washer

**

EP 12/01/23

Location

Loc Qty

Loc Code

ST297

2846

118354

705

119124

12

119736

2129

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Parent Item: D4149-041

D4149-041

Parent Item Name: Crosstube Lug Assembly, Aft

Start Date: 17/01/2012

Required Date: 31/01/2012

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0432R

Purchased

No

100

Each

3,454.000

6

12

NAS1149C0432R

**

Washer

CP 12/01/23

Location

Loc Qty

Loc Code

ST297

3454

117291

2454

119124

1000

12

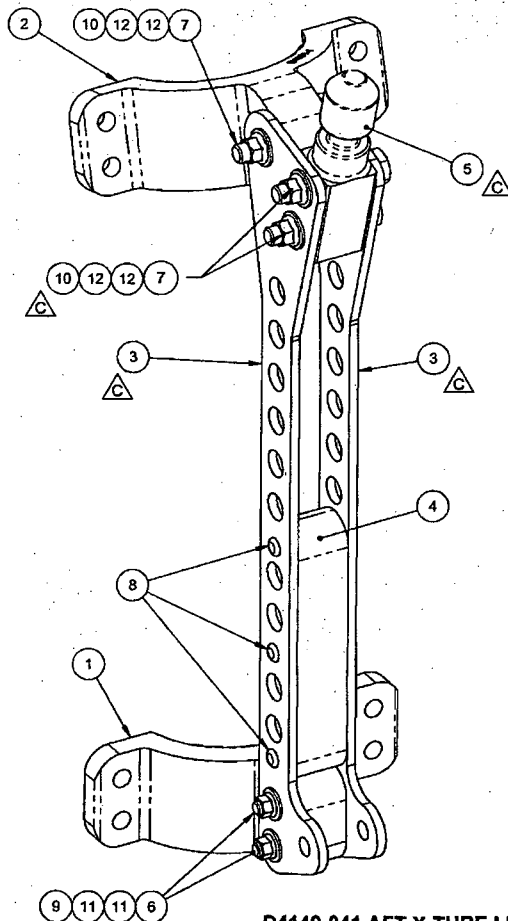
W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



D4149-041 AFT X-TUBE LUG ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.21 lbs

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SUBJECT
WITH
WO

NO 78971 M.L.J
12/01/17

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4149-041	AFT X-TUBE LUG ASSY
1	1	D3910-1	X-TUBE LUG
2	1	D4091-1	MOUNTING LUG
3	2	D4149-1	AFT X-TUBE LUG PLATE
4	1	D4149-3	SPACER
5	1	D4149-5	EYEBOLT STUD
6	2	AN3C12A	BOLT
7	3	AN4C13A	BOLT
8	3	MS20615-4M18	RIVET
9	2	MS21043C3	NUT
10	3	MS21043C4	NUT
11	4	NAS1149C0332R	WASHER
12	6	NAS1149C0432R	WASHER

RELEASED
2011-02-24
JW

C	HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, D7-2)	SC	11.02.22
B	MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); ADDED D4149-5 (SHT 5); D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D8-3); REASON: SEE TR-D350-907-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.18
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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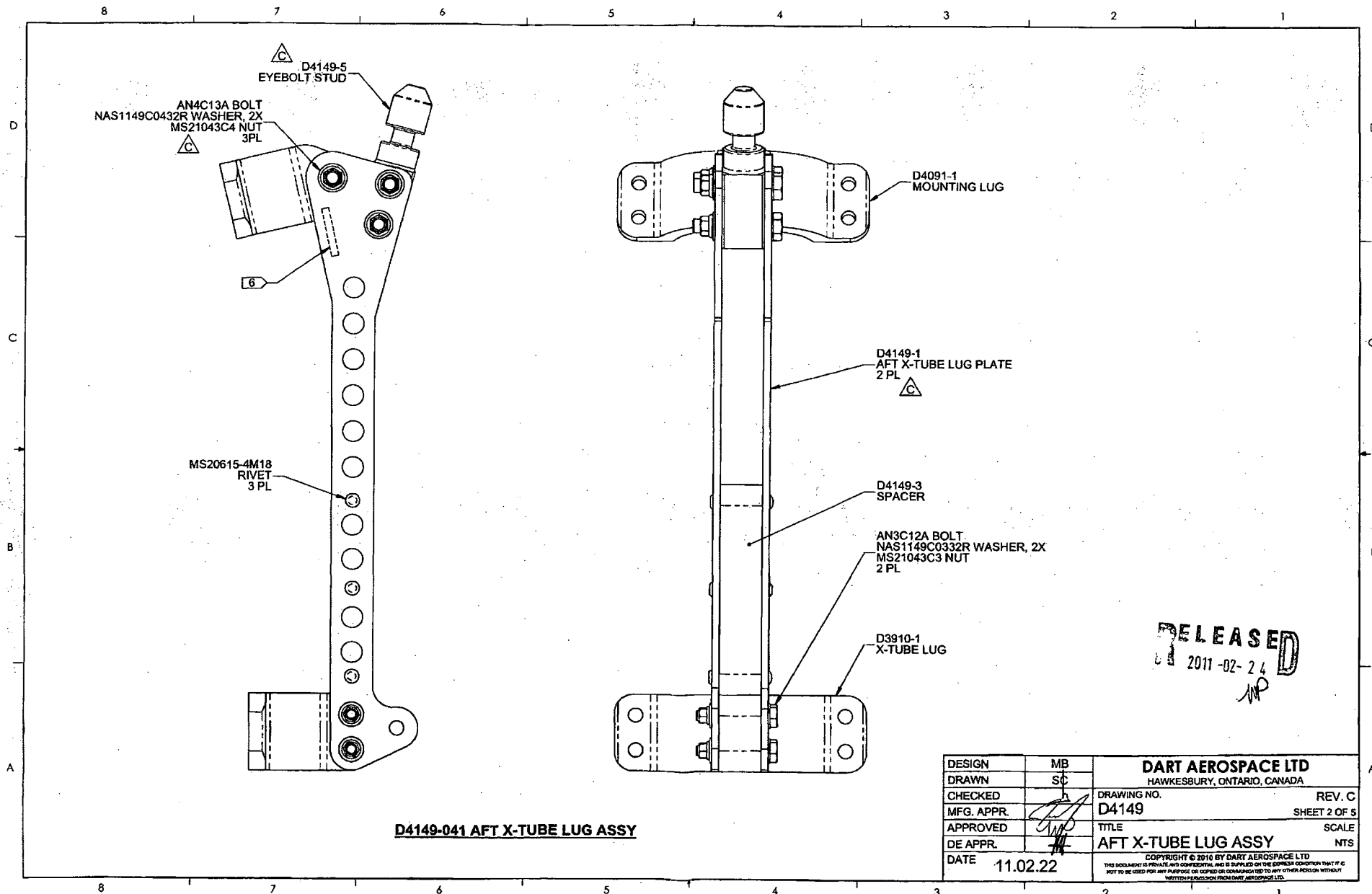
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D4149-041 AFT X-TUBE LUG ASSY

RELEASED
2011-02-24
MP

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
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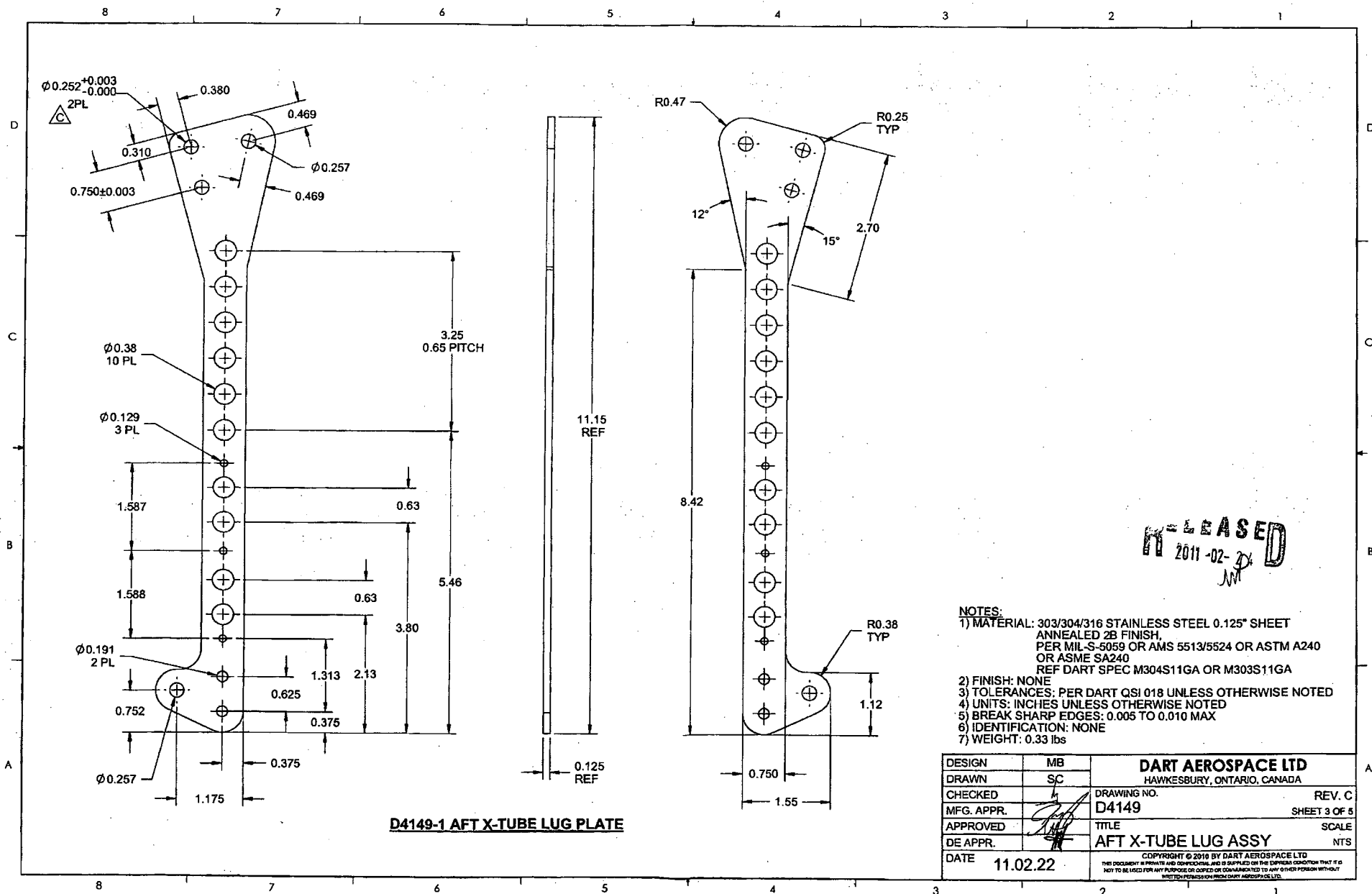
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D4149-1 AFT X-TUBE LUG PLATE

- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.33 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 3 OF 5
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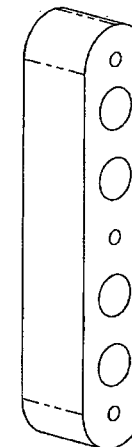
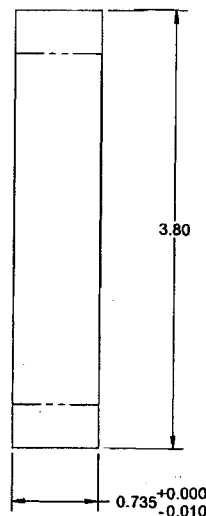
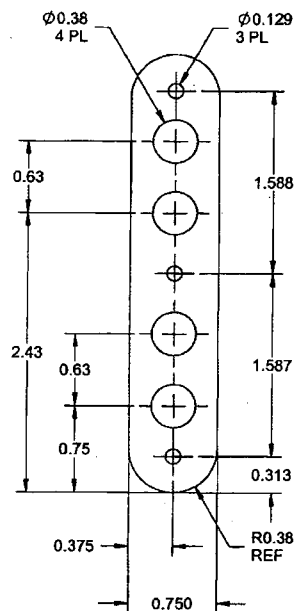
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D4149-3 SPACER

RELEASED
2011-02-22

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 4 OF 5
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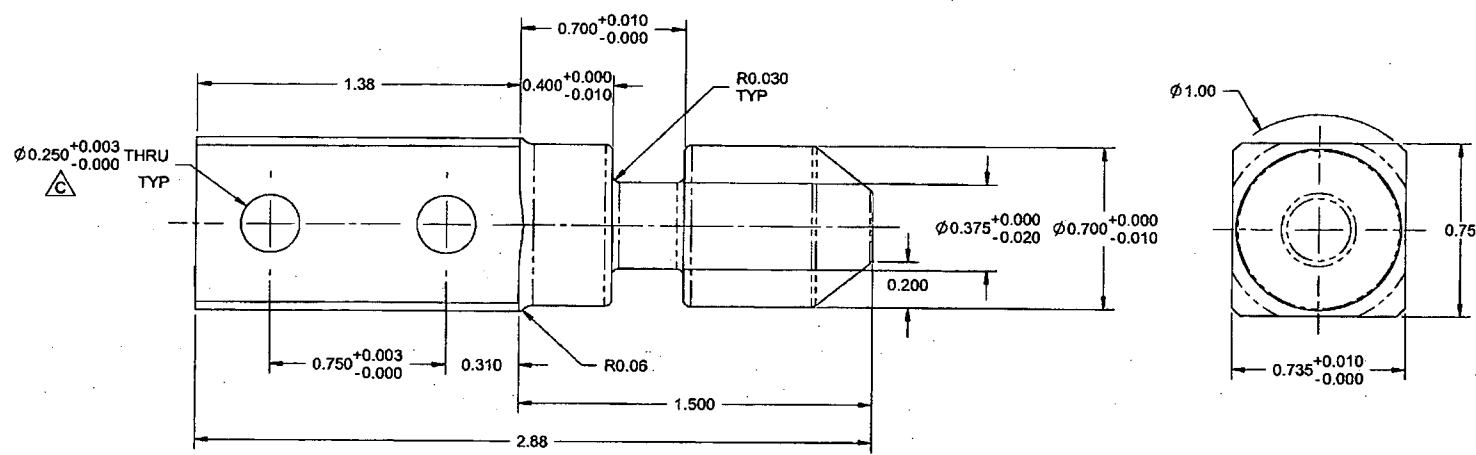
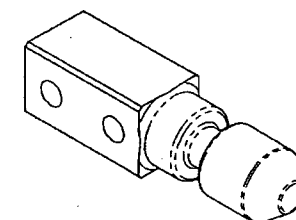
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D4149-5 EYEBOLT STUD

RELEASED
2011-02-26

- NOTES:
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.32 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 5 OF 5
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